		June												
Work Orde Wednesday, May													Page 1	_
Item ID: Revision ID:	D4038-044			Accept						Setup !				=
Item Name: Start Date: Required Date: Reference:	Angle Assemb 5/26/2010 6/4/2010	Start Qty: 2.00 Req'd Qty: 2.00				Cust Item II Customer:	<b>D</b> :				Stop			
Approvals:	Process Pla	nn:	Date: 10-3-0	E Toolin		Da	te:				Start Stop			
Sequence ID/ Work Center II	)	Operation Description		Set Run	Up/ Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	_
Draw Nbr	Rev	ision Nbr												-
D4038	В													
100 		Pick Kit  Memo		0.00	24	0/06/0	7		<u></u>					
110 Small Fab Small Fab		<b>Memo</b> Assemble	as per dwg	0.00	5b	60/06/07			2					
120		QC5- Inspect part com	apleteness to step on W/O	0.00										

Quality Control

Memo

0.00 Sidealis

<b>Dart Aerospace L</b>	_td
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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· · · · · · · · · · · · · · · · · · ·		L				·			
Part No		PAR #:							
	R	esolution:						Date:	
NCR:			WORK ORD	ER NON-CONFORMAI	NCE (NCF	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	n B Sign 8		cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	' Sect	ion C	Chief Eng	QC Inspector
·									
									:
	1			•					

### Work Order ID 59134

Wednesday, May 26, 2010 1:54:17 PM



Page 2

Item ID:

D4038-044

Accept

Setup Start



**Revision ID:** 

**Item Name:** 

Angle Assembly, Aft, RH

**Start Date:** 

5/26/2010

Start Qty: 2.00

Required Date: 6/4/2010

Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

QC:

Date: Date: Tooling:

Date:

Date:

Run

Start

Stop



Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:\_

Set Up/ **Run Hours** 

SPC (Y/N):

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Number

Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

10/06/09 TM

## **Dart Aerospace Ltd**

PROCEDURE CHANGE					
PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	PAR # Fault Category:				• Prod Mgr

Resolution:			Dispositio	n:	QA: N/C Clos	sed:	Date:								
NCR:			WORK ORDER NON-CONFORMANCE (NCR)												
DATE OFF		Description of NC		Corrective Action Section	В	Verification	Ammayal	Annua							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector							
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# **Picklist Print**

Wednesday, May 26, 2010 1:54:22 PM

Work Order ID: 59134

D4038-044

Parent Item Name: Angle Assembly, Aft, RH

Parent Item:

IPP REVA NEW ISSUE 10 04 21 II M VEDICIED DV.CC



**Start Date: 5/26/2010** 

Required Date: 6/4/2010

Page 1

Comments:	PP REV:A NEW	ISSUE 10-04-21 J	LM V	ERIFIED BY:	EC	:		5	Start Qty: 2.00	)	Requir	ed Qty: 2.0	00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4038-4		Manufactured	No			В	Each 5913	0.0000		2 S13	(0/06	107	<u></u>
D4038-8		Manufactured	No				Each	3.0000	1 	2			
D4038-12				Location ST110	57972	<u>Loc Q</u>	3	Loc Code	_	2-	So l	blac l	57 (2
94036-12 		Manufactured	No				Each	3.0000		2			
				Location ST110	57980	Loc Q	3 3	Loc Code				v /2	107 C
AN3-14A	<b>           </b>	Purchased	No		٠		Each	66.0000	2	4	SI 1	1/06	
	:			Location ST351	114330		66	Loc Code	<u>-</u>	4	So	10/06	107 (

Dart Aerospa	ce Ltd
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W/O:			W	ORK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CH	ANGE	В		Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
-	R	esolution:	Dispositi	on:	QA: N/	C Clo	sed:		Date:	
NCR:		\	WORK ORE	DER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC Section A	Initial	Action Description		gn &	Verific Section		Approval Chief Eng	Approval QC Inspector
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			-							

### **Picklist Print**

Wednesday, May 26, 2010 1:54:22 PM

Work Order ID: 59134

Parent Item: D4038-044

Parent Item Name: Angle Assembly, Aft, RH

Comments:

IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC

No



Start Date: 5/26/2010

Required Date: 6/4/2010

Page 2

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No				Each	1,710.000	2	4			

Nut

Location	Loc Qty	Loc Code	
ST300	1710		
113537	20		_
113644	190		
114523	1000		_
114718	500		
	Fach	674 0000	4

y Si volor lor

NAS1149D0363J Purchased

Washer

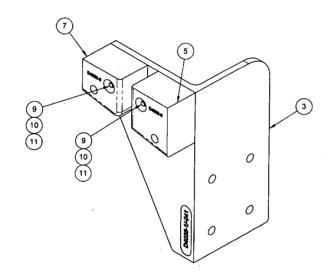
<b>Location</b>	Loc Qty	Loc Code
ST298	674	
113288	2	
114292	672	

B 1206/07 2

Dart A	erospace	<b>Ltd</b>
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W/O:			WC	RK ORDER CHANGE	S	<del></del>						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								4-4-19-64				
Part No		PAR #:										
	Re	solution:						Date:	<del></del>			
NCR:		•	WORK ORDE	ER NON-CONFORMAI	NCE (NCF	l)						
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approvai			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector			
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ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	х		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		X	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		. 1	D4038-6	BLOCK
7	1		D4038-9	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER



#### D4038-041 ANGLE ASSEMBLY, FWD, LH

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: -041 - 1.76 lbs
-042 - 1.74 lbs

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COFY SUBJECT TO AMENDMENT WITHOUT NOTICE 0 0

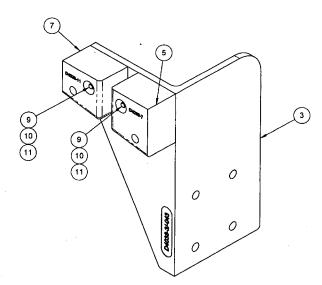
### D4038-042 ANGLE ASSEMBLY, FWD, RH

В	REVISE IN -1/-2	D DIMENSION 1-31-4 PARTS, A	S ALL SHEETS, ADD Ø0.316 HOLES ADD RADIUS TO -1/-2/-3/-4 PARTS	#	10.01.05			
Α	NEW IS	SUE		HS	09.12.14			
REV.			BY	DATE				
DESIG	N	A S	DART AEROSPA	CFT	חו			
DRAW	4	<b>8</b> 5	HAWKESBURY, ONTARIO, CANADA					
CHECKED B DRAWING NO.					REV. B			
MFG. A	PPR.	9/	D4038	s	HEET 1 OF 14			
APPRO	VED	NP,	TITLE		SCALE			
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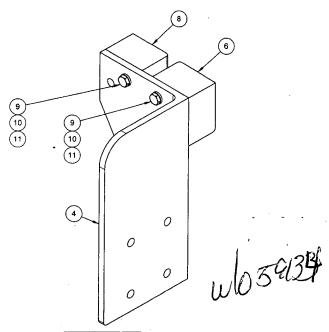
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W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	STEP PROCEDURE CHANGE By					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes N	o DQA	\:	Date:	
		esolution:								
NCR:				R NON-CONFORM						
DATE STEP		Description of NC	Description of NC Corrective Action				Verific	ation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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ITEM NO.	QTY. -043	QTY. -044	Part Number	DESCRIPTION
1	Х		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		х	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER



D4038-043 ANGLE ASSEMBLY, AFT, LH



2

**©4038-044 ANGLE ASSEMBLY, AFT, RH** 

D

DESIGN	1	DART AEROS	PACE LTD				
DRAWN	ab		HAWKESBURY, ONTARIO, CANADA				
CHECKED	B	DRAWING NO.	REV. B				
MFG. APPR.	91	D4038	SHEET 2 OF 14				
APPROVED	10	TITLE	SCALE				
DE APPR.	-#	BRACKET	NTS				
DATE 10.0	1.05	COPYRIGHT © 2009 BY DA THIS DOCUMENT IS PRIVATE AND CONTIDENTIAL AND IS SI NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COA	PPLED ON THE EXPRESS CONDITION THAT IT IS				

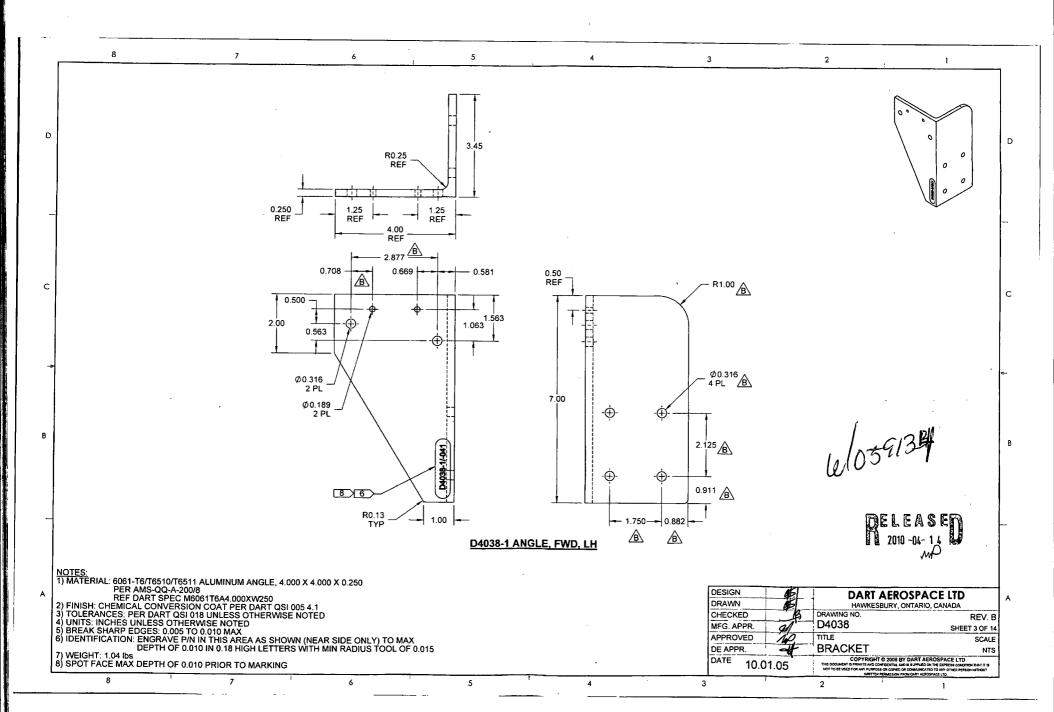
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART OSI 005.4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: -043 - 1.91 lbs
-044 - 1.74 lbs

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3

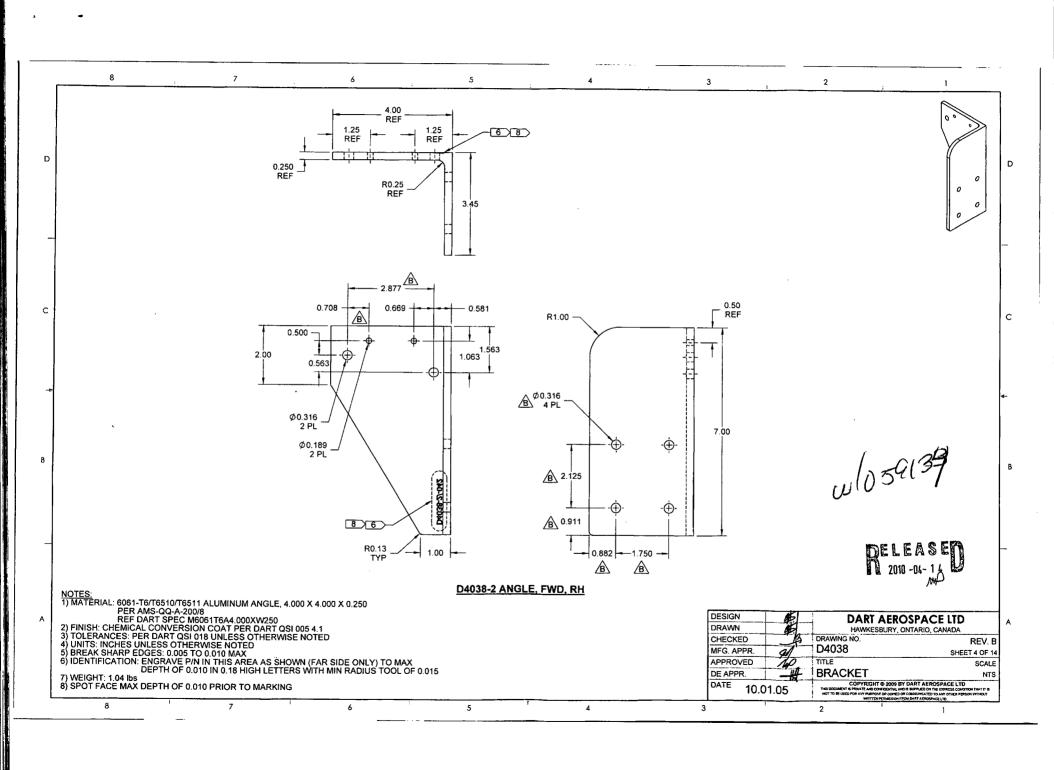
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	· · · · · · · · · · · · · · · · · · ·				
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NCR:			WORK OR	DER NON-CONFORMAI	NCE (NCR	)							
DATE OFF		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector				
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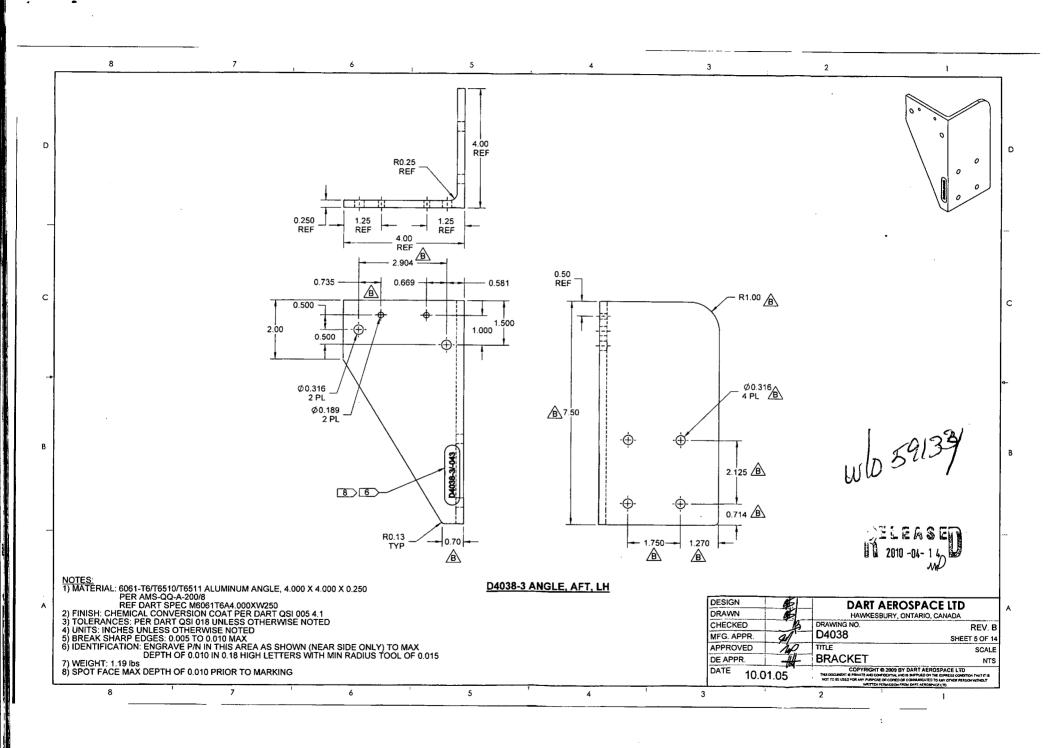
## **Dart Aerospace Ltd**

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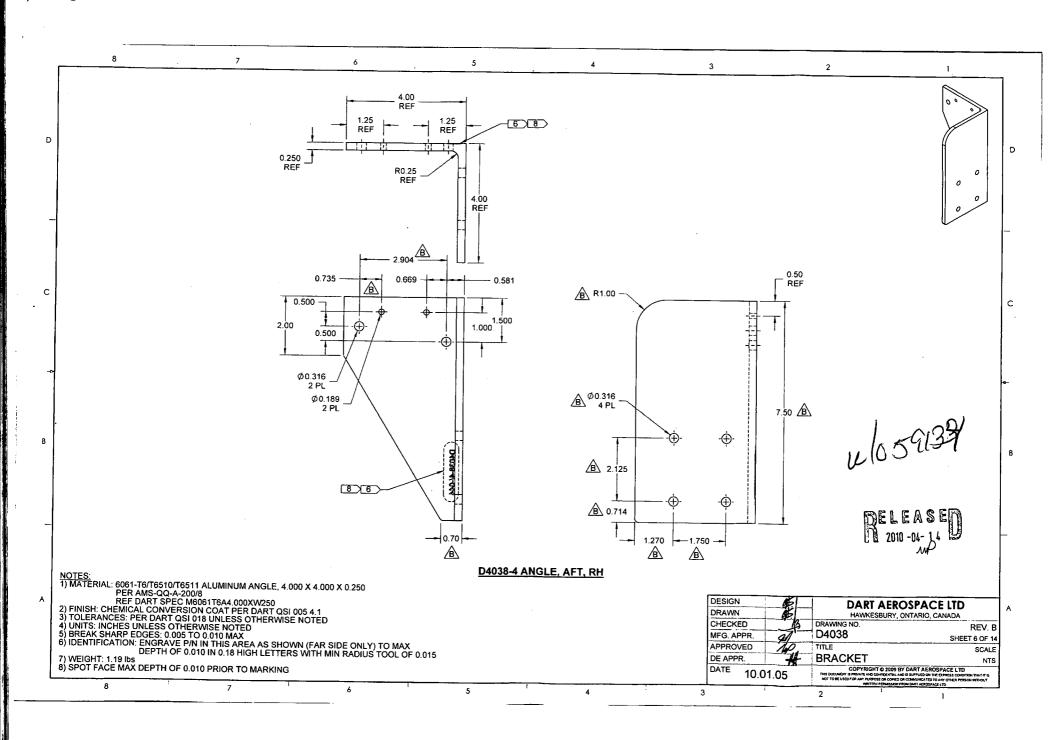
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NCR:			WORK ORDE	ER NON-CONFORM	IANCE	(NCR	)					
DATE	STEP	Description of NC	escription of NC Corrective Action			Section B Verif			Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
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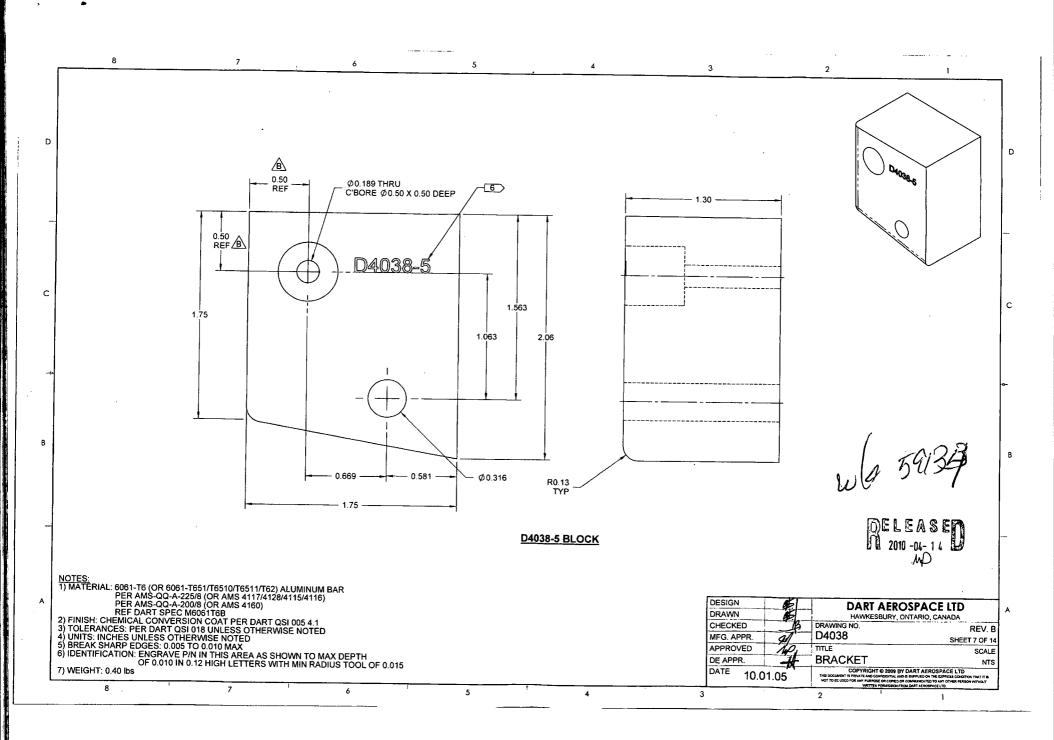
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DATE	STEP	PROCEDURE CHANGE			Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:						
	Res	solution:	Disposition	:	QA: N/C Closed: Date:						
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)		-			
DATE	STEP	Description of NC	Description of NC Corrective Action		n B			Verification		Approval	
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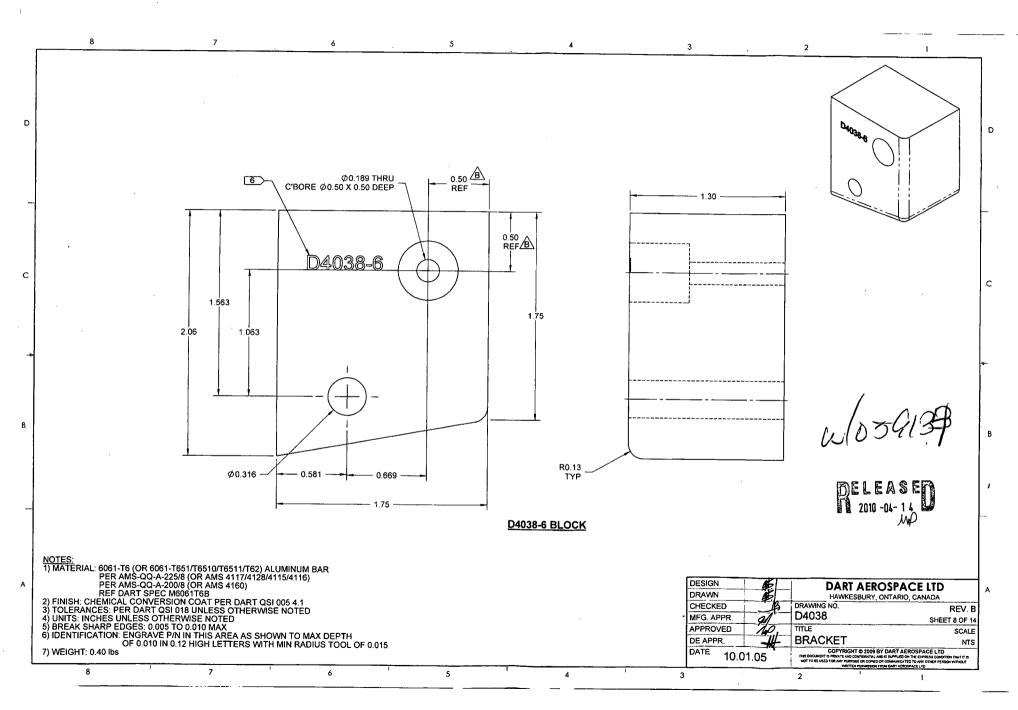
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DATE	STEP	Description of NC	Description of NC Corrective Action				ation	Approval	Approval
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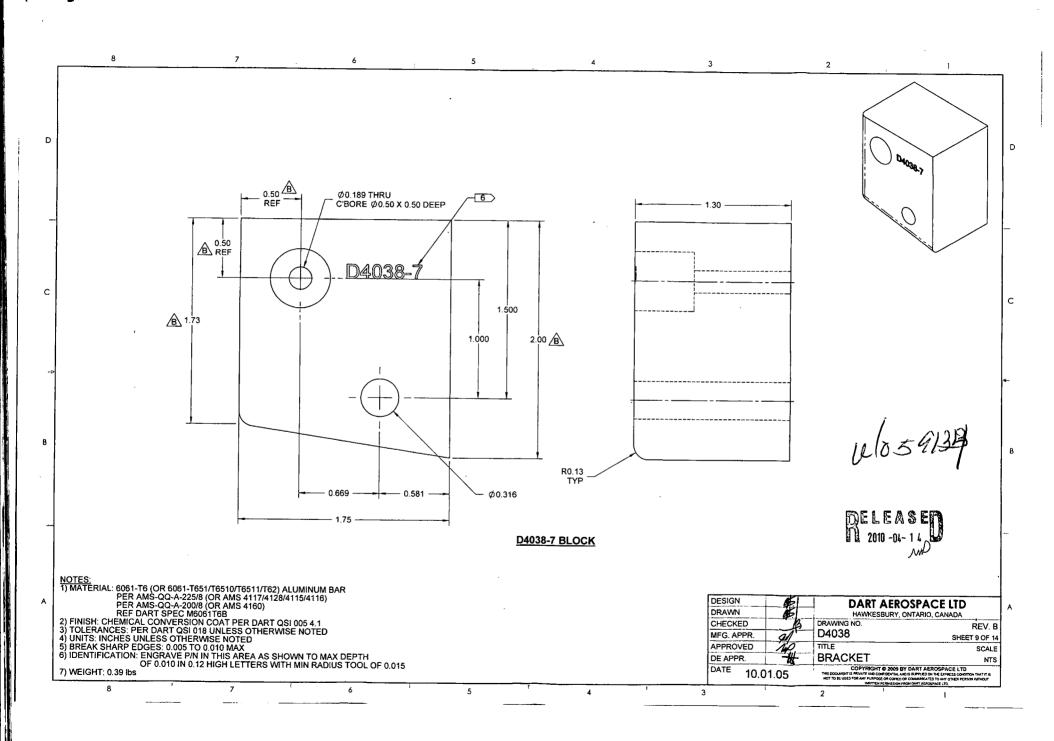
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		PAR #:	Fault Category: N			NCR: Yes No DQA: Date:					
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NCR:		•	WORK ORD	ER NON-CONFORM	IANCE (NO	CR)		7.744.644			
DATE STEP		Description of NC Corrective Action			ction B	Verit	ication	Approval	Approval		
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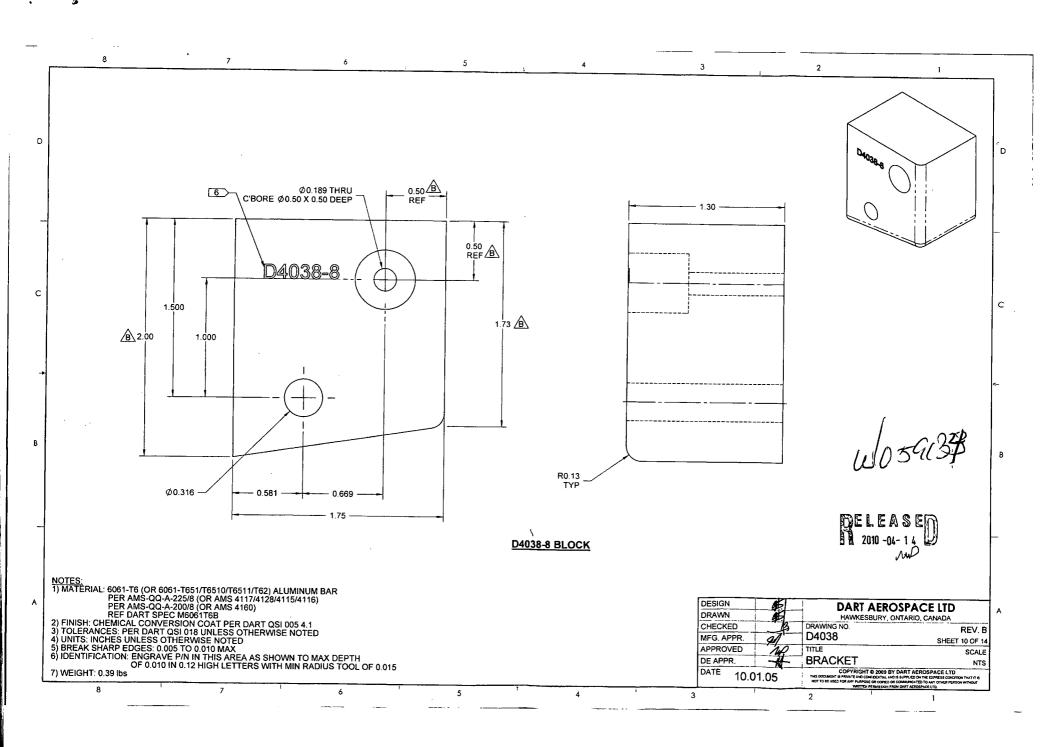
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Part No	•	PAR #:	Fault Categ	NCR: Yes No DQA: Date:								
	Re	esolution:	Disposition: Q			QA: N/C Closed: Date:						
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
DATE STEP		Description of NC	Corrective Action		tion B		Verification		Approval	Approval		
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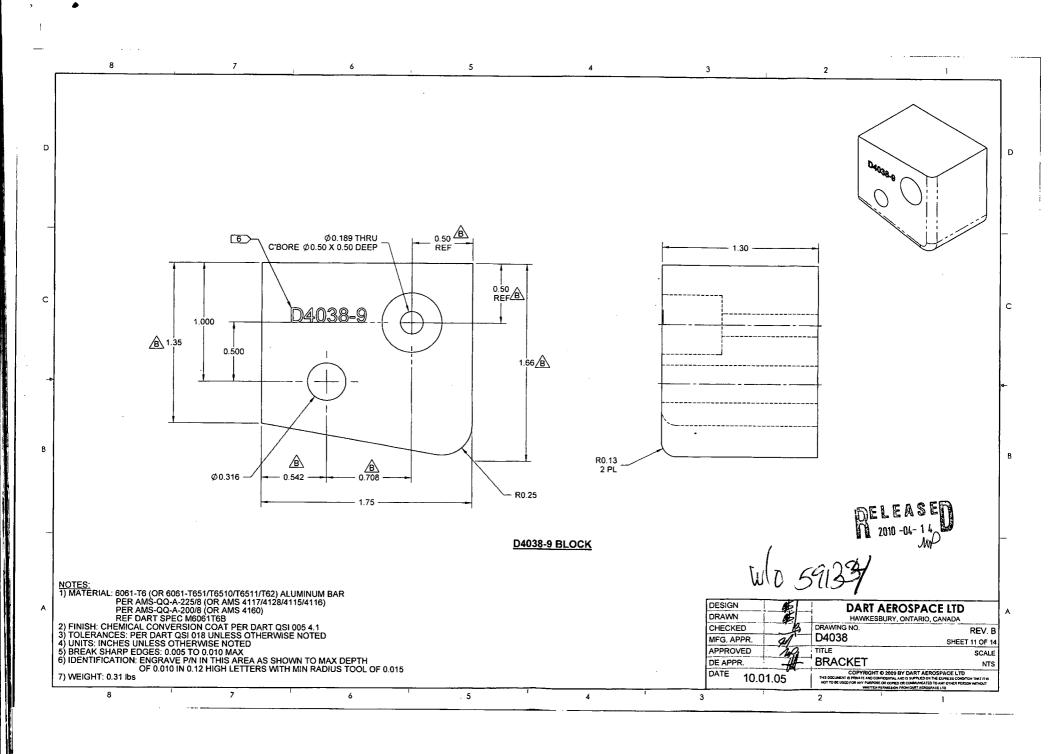


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	Re				QA: N/C Closed: Date:					
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)	-			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Section	on C	Chief Eng	QC Inspector	
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Dart Aerospac	ce Ltd	d
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W/O:			WORK ORDER CHANGES									
DATE STEP		PRO	OCEDURE CHAN	IGE	Ву			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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DATE	STEP	Description of NC Section A	Corrective Action Initial Action Description		Section B on Sign &		Verification Section C		Approval	Approval		
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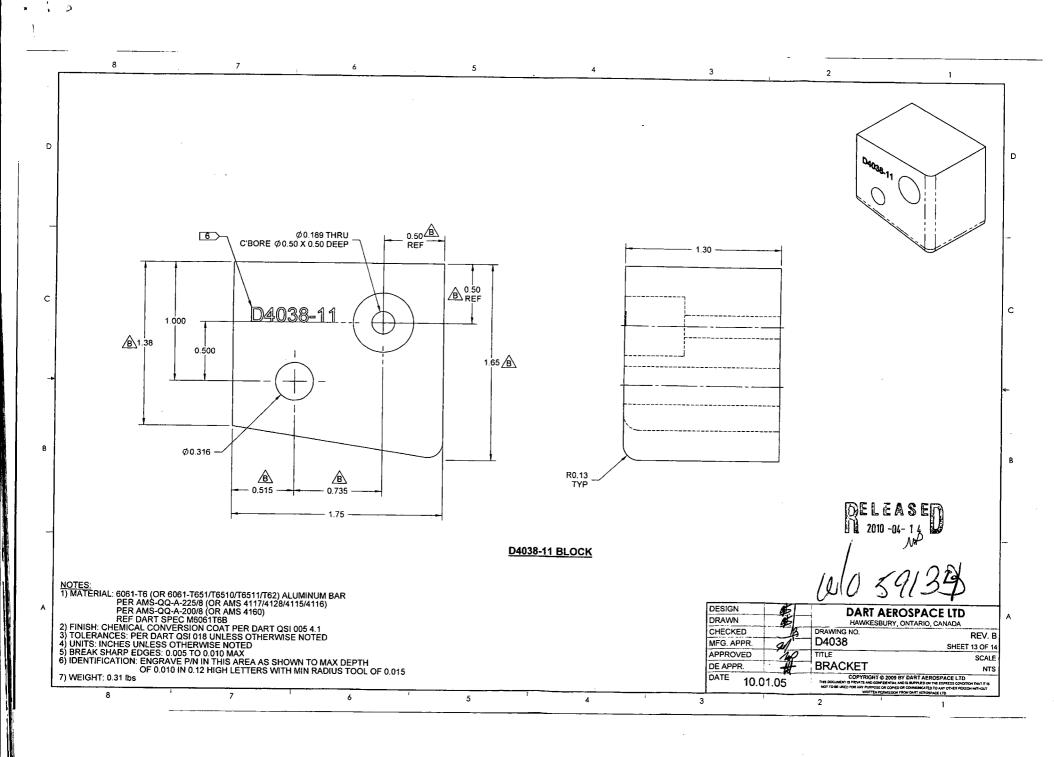
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W/O:		WORK ORDER CHANGES										
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NCR:		'	WORK ORI	DER NON-CONFORM	ANCE (N	CR)						
DATE	STEP	Description of NC			ion B		Verificatio	n Approval	Approval			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector			
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2 - 0.50 A Ø0.189 THRU C'BORE Ø0.50 X 0.50 DEEP 1.30 0.50 REF D4038-10 1.000 1.35 B 0.500 <u>₿</u> 1.66 Ø0.316 R0.13 B B 0.542 2 PL 0.708 R0.25 **D4038-10 BLOCK** NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D4038 MFG. APPR. SHEET 12 OF 14 APPROVED TITLE SCALE **BRACKET** DE APPR. NTS THE DOCARD IS PROVIDED TO 2009 BY DART AEROSPACE LTD.
THE DOCARD IS PROVIDE AND COMPONENT HOUSE SUPPLIED ON THE COPRESS CONTINUED TO DESCRIPTION OF COMMERCIAL TO NAME OF THE PROPERTY OF THE DATE 10.01.05

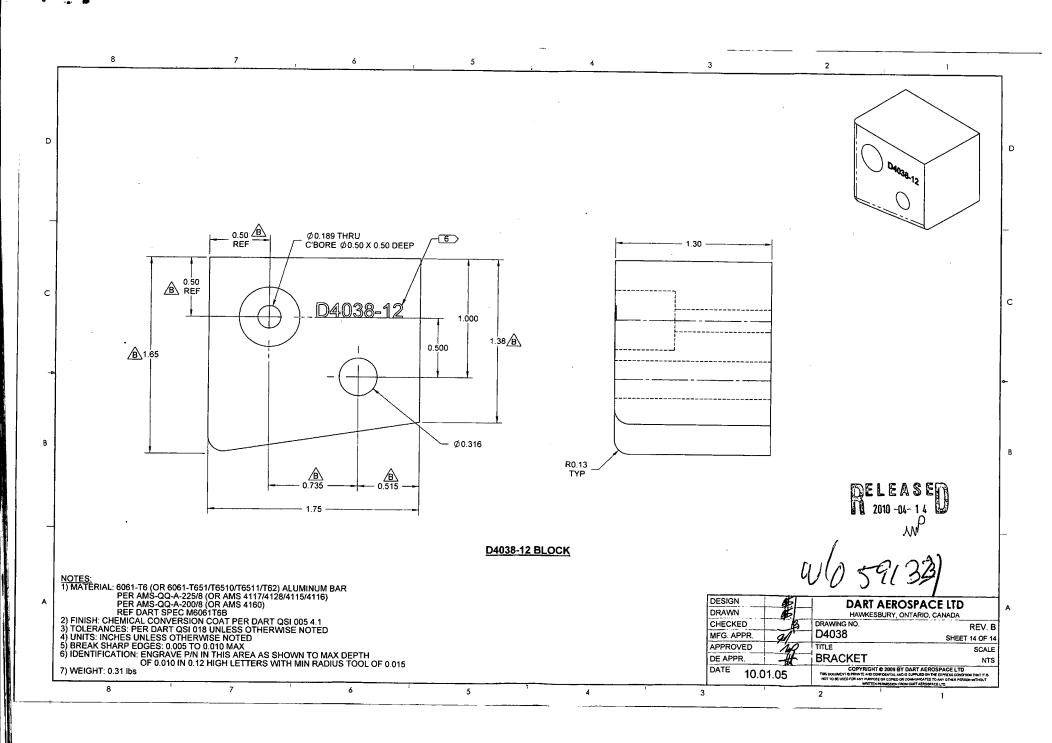
<b>Dart Aerospace Ltd</b>
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W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	PROCEDURE CHANGE			Da	ite Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			**							
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:					
	R	esolution:	Disposition:				QA: N/C Closed:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			tion B	v	erification	Approval	Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n &	Section C	Chief Eng	QC Inspector	
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<b>Dart Aerosp</b>	ace Ltd
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W/O:			WO	DV ODDED CHANC					
DATE	STEP	PROCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No						Yes No DQA: Date:			
NCR:		T		R NON-CONFORMA					
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descript Chief Eng Chief Eng		on B Sign 8				
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W/O:			V	VORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Disposit	ion:	QA: N/C Closed:			Date:	
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC	Corrective Action Section		n B	Verifi	cation	Annuaral	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Approval Chief Eng	

NCR:			WORK ORDI	ER NON-CONFORMANO	SE (NCR)								
DATE	0755	Description of NC		Corrective Action Section B	Verification		Ι						
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector					
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